

Work Order ID 59441

Friday, June 04, 2010 10:27:39 AM



Page 1

Item ID: D3912-1

Accept



Setup Start



Revision ID:

Item Name: Eyebolt

Stop



Start Date: 6/4/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-6-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3912

A

100

0.00



Doosan

Memo

0.00

Doosan Lathe

TURN AS PER FOLIO FA871 AND DWG

Prog Rev:

Dwg Rev: A

Deburr as required

SL 10/06/14 (12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SL 10/06/14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 59441

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

L.S. 10/06/14

12

Ø

130

Identify as per dwg & Stock Location: *96*

0.00



Packaging

Memo

0.00

Packaging

10-6-15 *(120) SP*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/15 *[Signature]*

RD 10-6-15
(12)

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Friday, June 04, 2010 10:27:43 AM

Page 1

Work Order ID: 59441



Parent Item: D3912-1



Parent Item Name: Eyebolt

Start Date: 6/4/2010

Required Date: 6/10/2010

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 12.00

Required Qty: 12.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M303R2.000 | | Purchased | No | | | 100 | f | 5.8400 | 0.25 | 3.157895 | | | |



303 ROUND BAR 2"

Location

Loc Qty

Loc Code

MAT029

5.84

113341

5.84

3.0 JL 10/06/14

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

| | | |
|------------------------------|---------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 59441 |
| Description: eye bolt | | Part Number: D3912-1 |
| Inspection Dwg: D3912 | Rev: A | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---|---|------------------|--------|--------|----------------------|----------|
| 2.28 | ±.030 | 2.282 | ✓ | | | |
| 1.25 | ±.030 | 1.253 | ✓ | | | |
| .625 | ±.010 | .625 | ✓ | | | |
| 5.13 | ±.030 | .125 | ✓ | | | |
| 5.015 | ±.010 | .015 | ✓ | | | |
| .13 | ±.030 | .132 | ✓ | | | |
| .500 | ±.010 | .500 | ✓ | | | |
| .700 | ±.010 | .700 | ✓ | | | |
| .90 | ±.030 | .898 | ✓ | | | |
| 13x45° | ±.030 ±.5° | 140x45° | ✓ | | | |
| .800 | ±.010 | .800 | ✓ | | | |
| 1.60 | ±.030 | 1.601 | ✓ | | | |
| .625 | ±.010 | .626 | ✓ | | | |
| .438 | ±.010 | .439 | ✓ | | | |
| 1.10 | ±.030 | 1.100 | ✓ | | | |
| 1.75 | ±.030 | 1.752 | ✓ | | | |
| 1.00 | ±.030 | 1.00 | ✓ | | | |
| .30 | ±.030 | .297 | ✓ | | | |
| .88 | ±.030 | .880 | ✓ | | | |
| .11 | ±.030 | .109 | ✓ | | | |
| .719 | ±.010 | .723 | ✓ | | | |
| 5.13 | ±.030 | .125 | ✓ | | | |
| Ø.397 ^{+0.006} _{-0.001} | Ø.397 ^{+0.006} _{-0.001} | .397 | ✓ | | | |

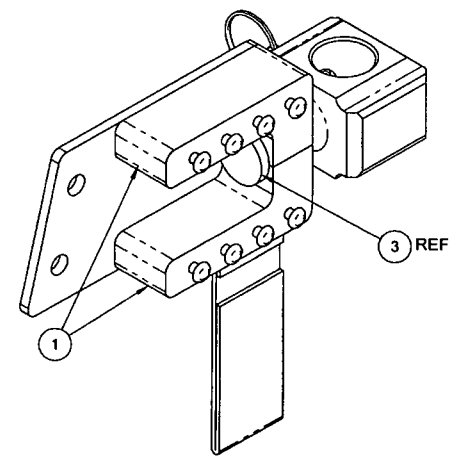
| | | | |
|------------------------|--------------------------------|----------------------------|-----|
| Measured by: JH | Audited by: [Signature] | Prototype Approval: | N/A |
| Date: 10/06/20 | Date: 10/06/14 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |

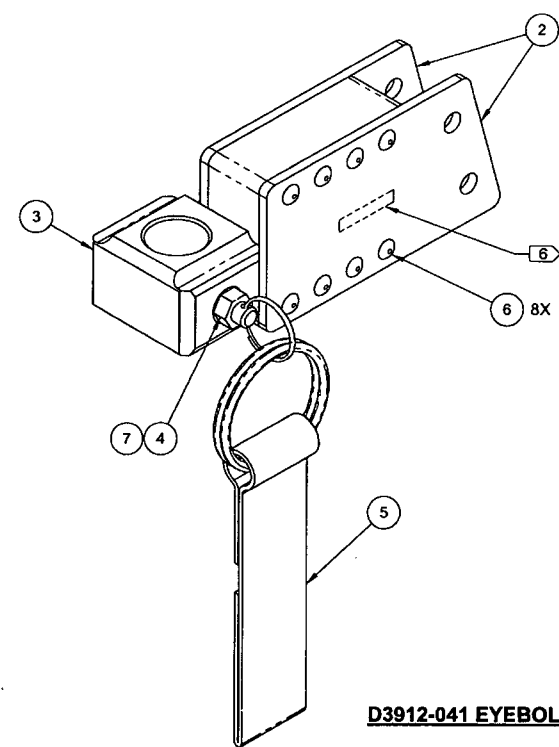
SHOP COPY

ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59441
10-6-09

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|--------------|-------------------------|
| | X | D3912-041 | EYEBOLT RECEIVER ASSY |
| 1 | 2 | D3912-3 | EYEBOLT BLOCK |
| 2 | 2 | D3912-5 | EYEBOLT PLATE |
| 3 | 1 | D3912-1 | EYEBOLT |
| 4 | 1 | D3810-1 | SPRING PLUNGER |
| 5 | 1 | D4028-041 | SPRING PIN LANYARD ASSY |
| 6 | 8 | MS20615-4M20 | RIVET |
| 7 | 1 | MS21209-C610 | HELICAL (RED LOCKING) |



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)



D3912-041 EYEBOLT RECEIVER ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT -041: 1.68 lbs

RELEASED
2010-03-12
MP

| A | NEW ISSUE | DESCRIPTION | JPH | 10.03.04 |
|------------|-----------|--|--------------|----------|
| REV. | | | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| DRAWN | JPH | | | |
| CHECKED | GP | DRAWING NO. D3912 | REV. A | |
| MFG. APPR. | GP | | SHEET 1 OF 3 | |
| APPROVED | MP | TITLE | SCALE | |
| DE APPR. | MP | EYEBOLT RECEIVER ASSY | NTS | |
| DATE | 10.03.04 | <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | | |

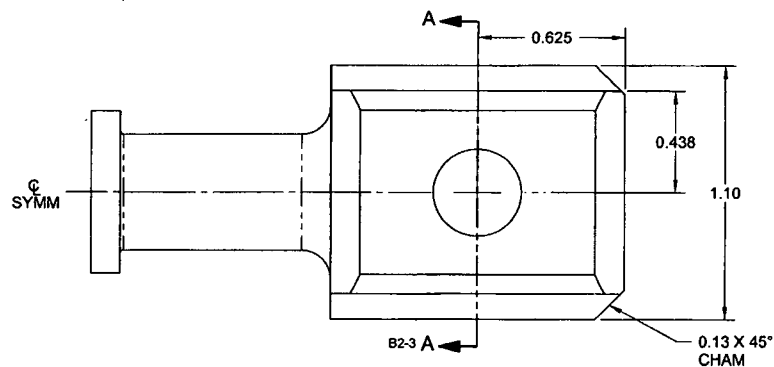
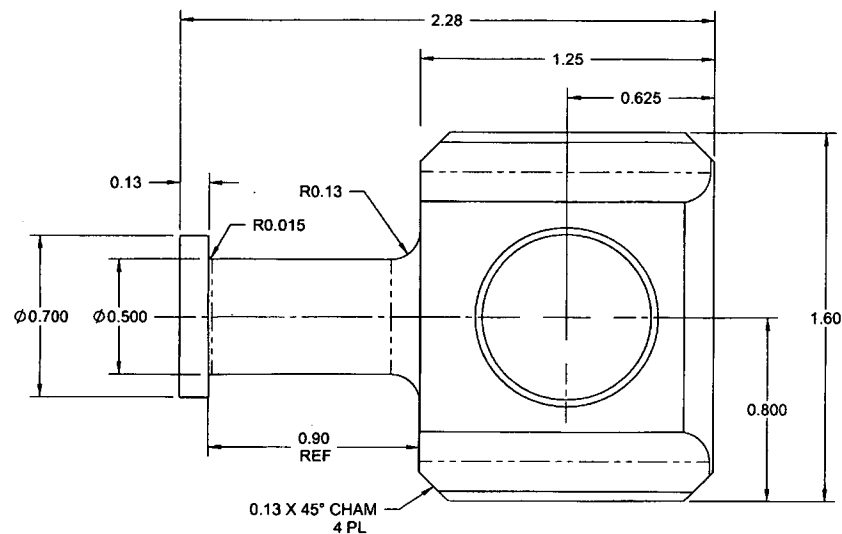
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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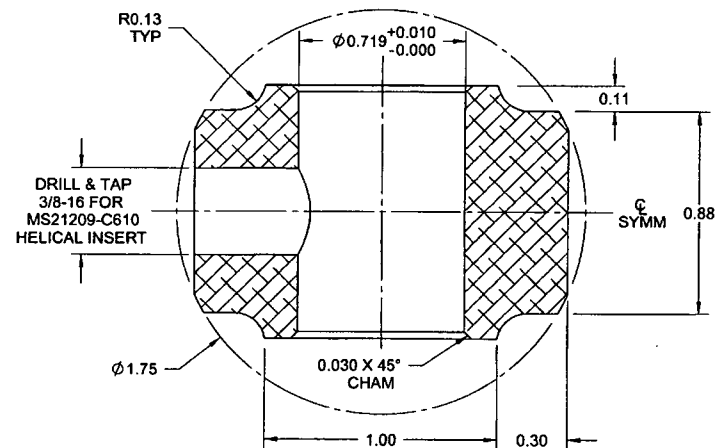
NOTE: Date & initial all entries



D3912-1 EYEBOLT

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.49 lbs



SECTION A-A B6-3

RELEASED
2010-03-12
JMP

| | | | |
|------------|----------|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | JPH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | JPH | DRAWING NO. | REV. A |
| MFG. APPR. | JPH | D3912 | SHEET 2 OF 3 |
| APPROVED | JPH | TITLE | SCALE |
| DE APPR. | JPH | EYEBOLT RECEIVER ASSY | NTS |
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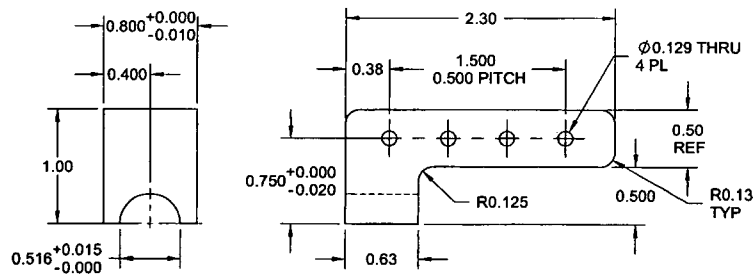
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

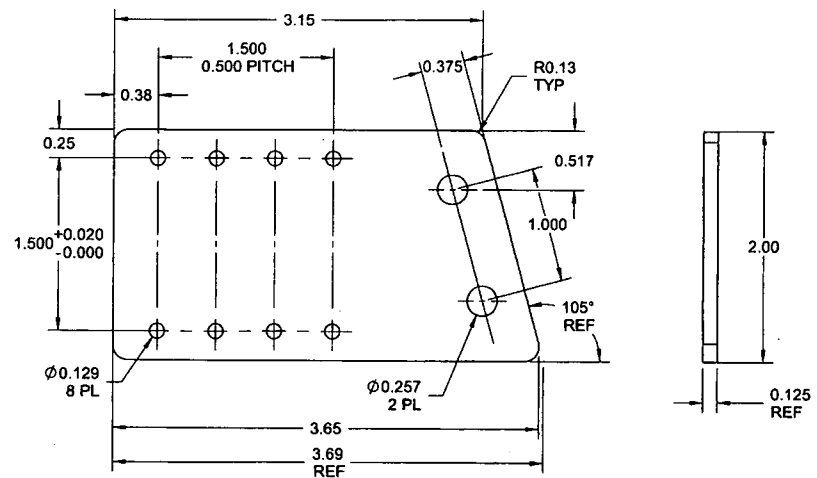
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NOTE: Date & initial all entries

W/O 59447



D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: ID AT ASSEMBLY

7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

RELEASED
2010-03-12
JMP

| | | | |
|------------|--------------------|------------------------------|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | JPH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. A |
| MFG. APPR. | <i>[Signature]</i> | D3912 | SHEET 3 OF 3 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | EYEBOLT RECEIVER ASSY | |
| DATE | 10.03.04 | NTS | |

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